Work Order Thursday, January							**			439		Page 1
Revision ID:	03213-1 Poor Panel			Acc	ept					Setup Sta		
Start Date: 1/ Required Date: 1/ Reference:	/6/2011 /14/2011	Start Qty: 8.00 Req'd Qty: 8.00				Cust Item I Customer:	D:				110011110	1818 118 1181 1881
	Process Plan	n:	Date//-07	•	ooling: PC (Y/N):		ate:		]	Run Sta Sto		
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3213	Revi Rev	sion Nbr A										
Waterjet FLOW CNC Waterjet ついろく .063			per Dwg D3213 DDv necessary		0.00 0.00 ▲□Prog Rev:_	₽ □2-			<u> HB</u> (	1-1-10	\(\delta\)	· · · · · · · · · · · · · · · · · · ·
110  QC  Quality Control		QC2- Inspect parts of	machine FAI/FAIB		0.00				B(1-	1-10		- <u></u>
120 		QC8- Inspect parts - s	econd check		ols, 2 00.0	allo			(XE			

Quality Control

Page 2

Item ID:

D3213-1

Thursday, January 06, 2011 3:29:30 PM

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Door Panel

**Start Date:** 1/6/2011

Start Oty: 8.00

Required Date: 1/14/2011

Req'd Qty: 8.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:\_\_\_\_\_

**SPC (Y/N):** 

Date:

Stop



Sequence ID/ **Work Center ID** 

Small Fab

Small Fab

Operation **Description** 

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

2) M 11/08/08

Hand Finishing

Memo

0.00

150

QC3- Inspect Part Finish

0.00

0.00

8 BR 11-01-11

Quality Control

Memo

#### Work Order ID 65142

Thursday, January 06, 2011 3:29:30 PM



Page 3

Item ID:

D3213-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Door Panel

**Start Date:** 1/6/2011 Start Qty: 8.00

Required Date: 1/14/2011 Req'd Qty: 8.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

**Process Plan:** 

Date:

Tooling:

Date:

Run

Start

Stop



Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Reject

Reject Insp.

160

Work Center ID

Sequence ID/

Packaging

Packaging

Operation Description

Memo

Memo

**Run Hours** Identify as per dwg & Stock Location: 57 2326

0.00

Tool # Plan Code

Accept Oty

Otv

Number Stamp

170

Quality Control

0.00

QC21- Final Inspection - Work Order Release

0.00

## **Picklist Print**

Thursday, January 06, 2011 3:29:36 PM

Work Order ID: 65142

Parent Item:

D3213-1

Parent Item Name: Door Panel



Start Date: 1/6/2011

Required Date: 1/14/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A 05-11-17 New Issue

JLM

IPP Rev:B 07-02-13 Now on Waterjet JLM

IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last . Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	70.5000	0.4714	3.969684	ļ		
										B 1	1-1-10		·

2024-T3 .063 sheet

Location Loc Qty Loc Code MAT22 70.5 114351 114351 70.5

DART AEROSPACE LTD	Work Order:	15142
Description: Door Panel	Part Number:	D3213-1
Inspection Dwg: D3213 Rev: A		Page 1 of 1

	FIRS	T ARTICLE I	NSPECTI	ON CH	ECKLIST		
	<u> </u>	First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
15.00	+/-0.030	15,00	xp		TBO(		
4.47	+/-0.030	4.479	20		U B62		
14.400	+/-0.005	14.400	ک		7		
0.300	+/-0.010	-309	7	·	V		
Ø0.128	+0.005/-0.001	(13)	x		V		
Pitch 2.057	+/-0.005	8201G	>		V		
		<u> </u>					
	1						
	.*		·				
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Measured by:	\$	Audited by:	8		Prototype App	oroval:	N/A

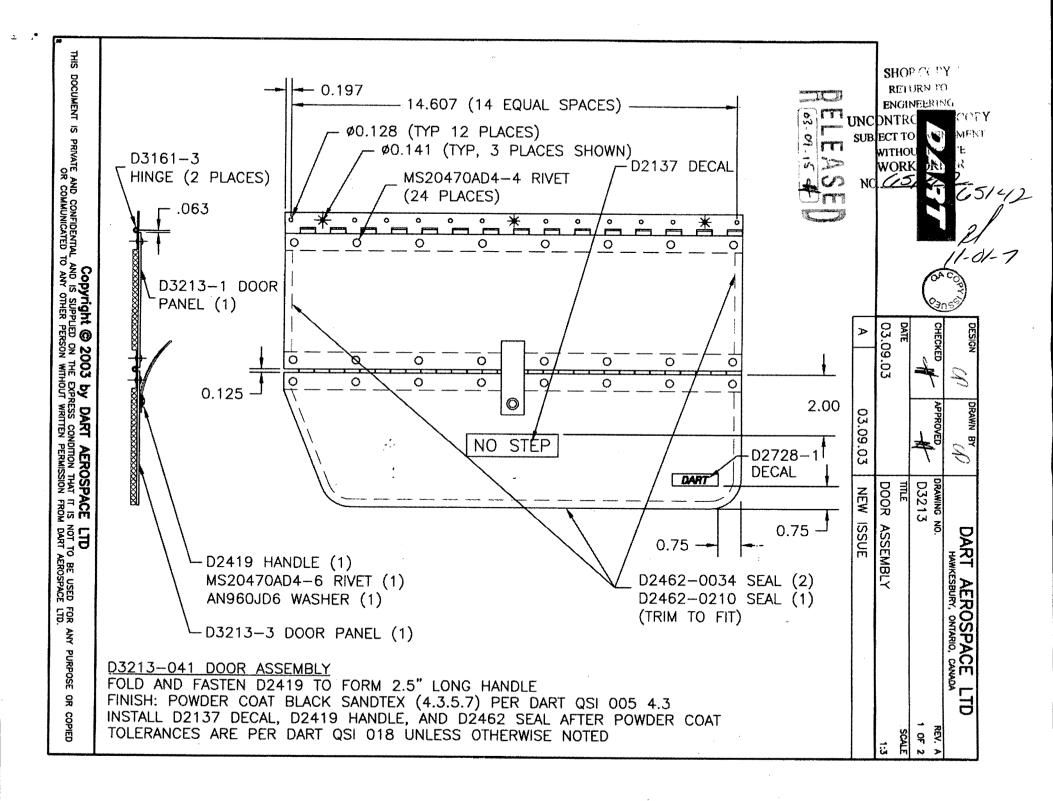
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-1-10	Date: 11 Olio	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.12.15	New Issue	P/O D350-567-015/-025/-031	KJ/RF	
В	08.11.27	Diameter symb	ol added to dimension 0.128	KJ/EC X	1
				- ' ' ' '	-

### **Dart Aerospace Ltd**

	12									
W/O:			WO	RK ORDER CHANGE	ES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							}			
Part No	•	PAR #:	Fault Cated	NCR: Yes	No <b>DQ</b>	Date:				
		esolution:								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	7)				
DATE	CTED	Description of NC		Corrective Action Section B			cation	ion Approval	Approval	
DAIE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector	
					Ì	:				
								:		

NOTE: Date & initial all entries



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No	•	PAR #:	Fault Cated	orv.	NCR: Yes	No DC	)Δ·	Date:				
		esolution:										
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)						
DATE		Description of NC		Corrective Action Section		Verif	ication	Approval Chief Eng	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	Section C					
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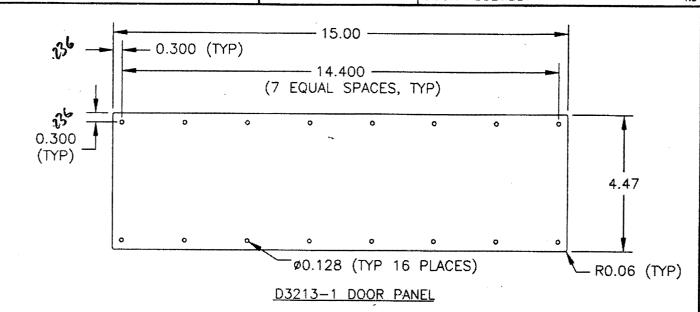
NOTE: Date & initial all entries

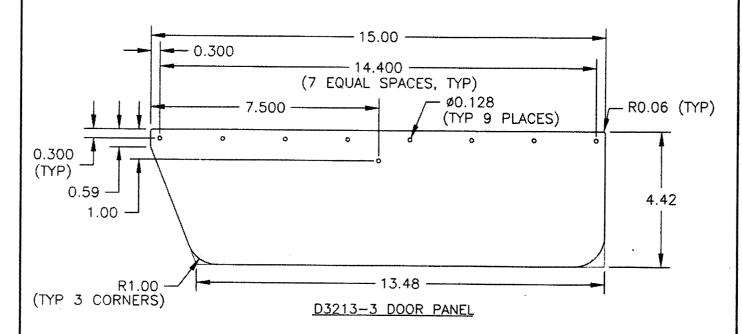
w/0 65142





`	DESIGN ()	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO,	
•	CHECKED MI	APPROVED	DRAWING NO.	REV. A
7	de	all	D3213	2 OF 2
	DATE		TITLE	SCALE
	03.09.03		DOOR ASSEMBLY	1:3





D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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### **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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r's						č						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQA</b> :_	Date: _					
					QA: N/C Closed: Date:							
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NCR	)						
DATE		Description of NC		tion B	Verificati	on Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (		QC Inspector				
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NOTE: Date & initial all entries